

**Work Order ID 64170**

Friday, November 26, 2010 10:44:38 AM



Page 1

Item ID: D3916-041

Revision ID:

Item Name: Rib Assembly

Start Date: 11/26/2010 Start Qty: 6.00

Required Date: 12/3/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:



Date: 10-11-26

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr								
D3916	A								

100



Large Fab

Memo

0.00

(6) 10/12/101

Large Fab

1- Cut tube 50"  
 2- Bend tube with manuel pipe bender as per DT9567  
 \*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*  
 3- Trim access tube material to finish size as per dwg D3916  
 4- Drill and chamfer holes as per dwg D3916-1 using DT9605  
 5- weld bushing as per dwg D3916  
 6- grind welds flush

SAD 10-12-15

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

SAD 10-12-121

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 64170**

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Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 11/26/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

10/12/21

6 ✓

130



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Basket cell  
Memo

0.00

10/12/21 ✓

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/21 ✓

MF  
10-12-21

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Friday, November 26, 2010 10:44:43 AM

Page 1  
✓

Work Order ID: 64170



Parent Item: D3916-041



Parent Item Name: Rib Assembly

Start Date: 11/25/2010

Required Date: 12/3/2010

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP RevB as

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 	Manufactured	No			100	Each	23.0000	7		42		(P 10.12.17)	
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Bushing

Location	Loc Qty	Loc Code
ST084	3	
56942	3	
WA	20	
54072	9	
63875	11	

M304TS0.750W.049 	Purchased	No		100	f	131.5207	4.166	26.31158				SAD 10-12-15
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304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
MAT	8.15036794	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	123.3703	
114992	31.6993	
115260	91.671	

m116319 →

17.5416 + 3.000 = END Bar  
8.770 Scrap

W/O:		WORK ORDER CHANGES					
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ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

8  
7  
6  
5  
4  
3  
2  
1  
D  
C  
B  
A

SHOP COPY

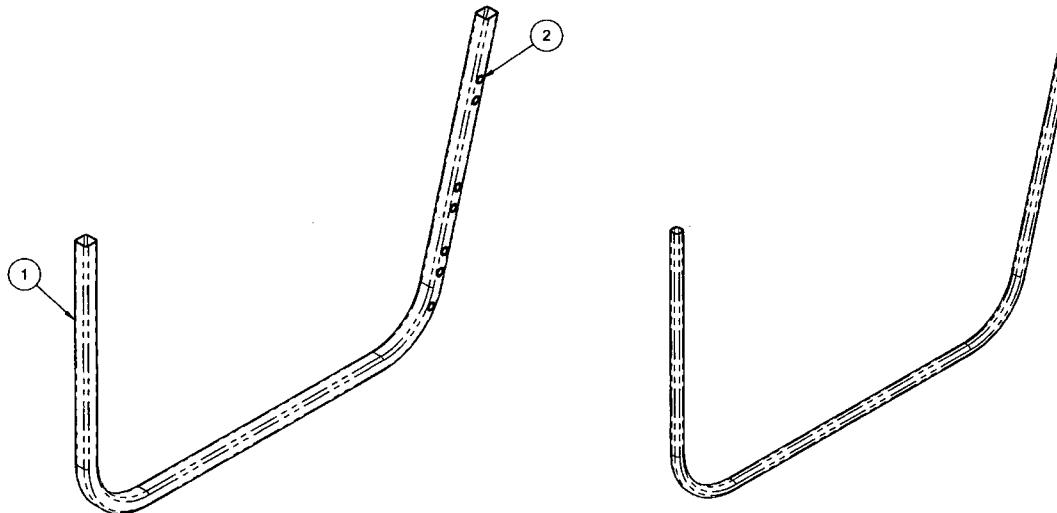
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 641120

*BSR-10-11-26*



D3916-041 RIB ASSY

D3916-5 LIGHT RIB

RELEASED  
2010-03-12  
*M.P.*

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>90</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>E</i>	D3916	SHEET 1 OF 4
APPROVED	<i>NW</i>	TITLE	SCALE
DE APPR.	<i>NW</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED FOR INTERNAL USE ONLY AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8  
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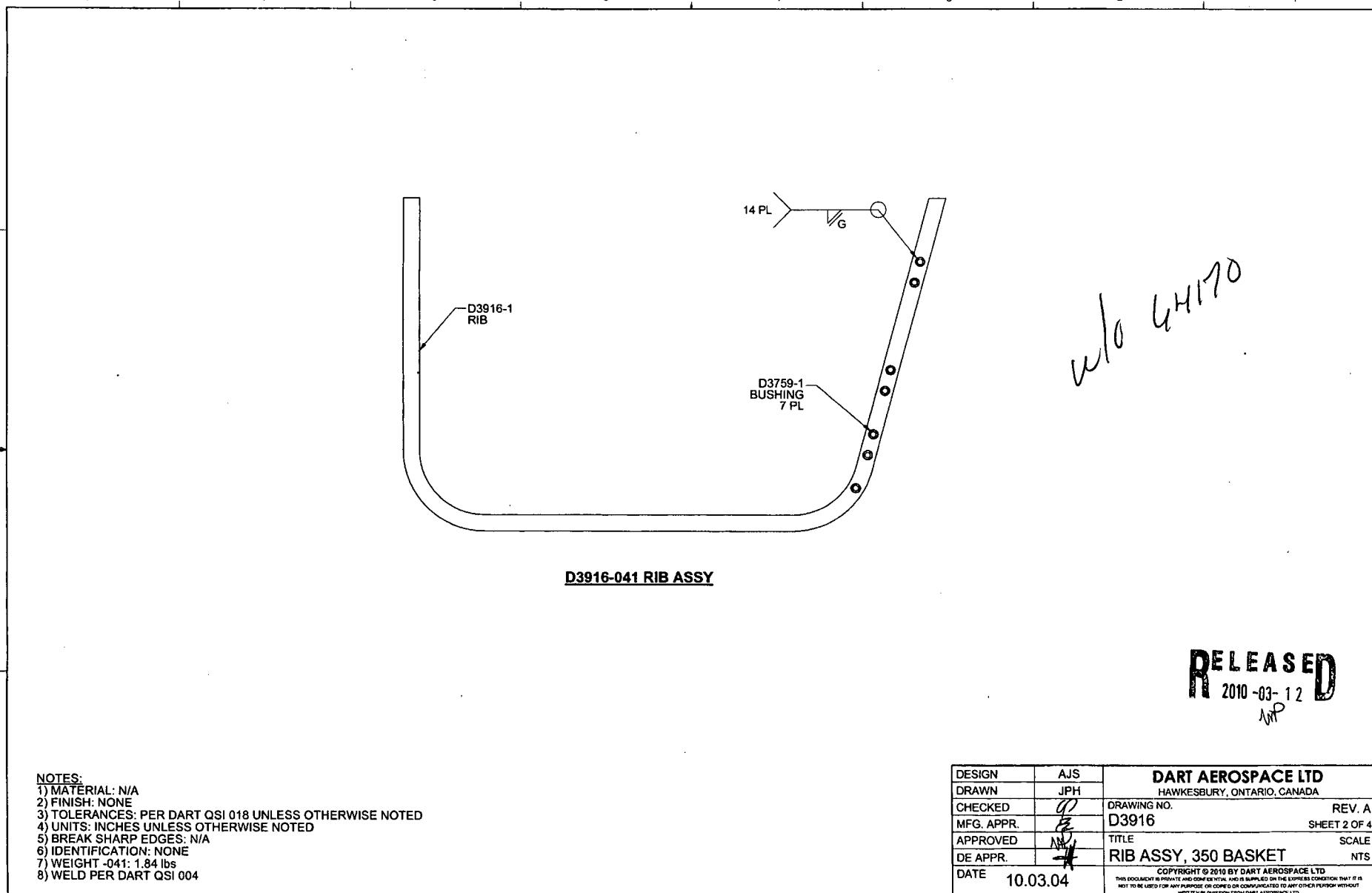
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**RELEASED**  
2010-03-12  
*NP*

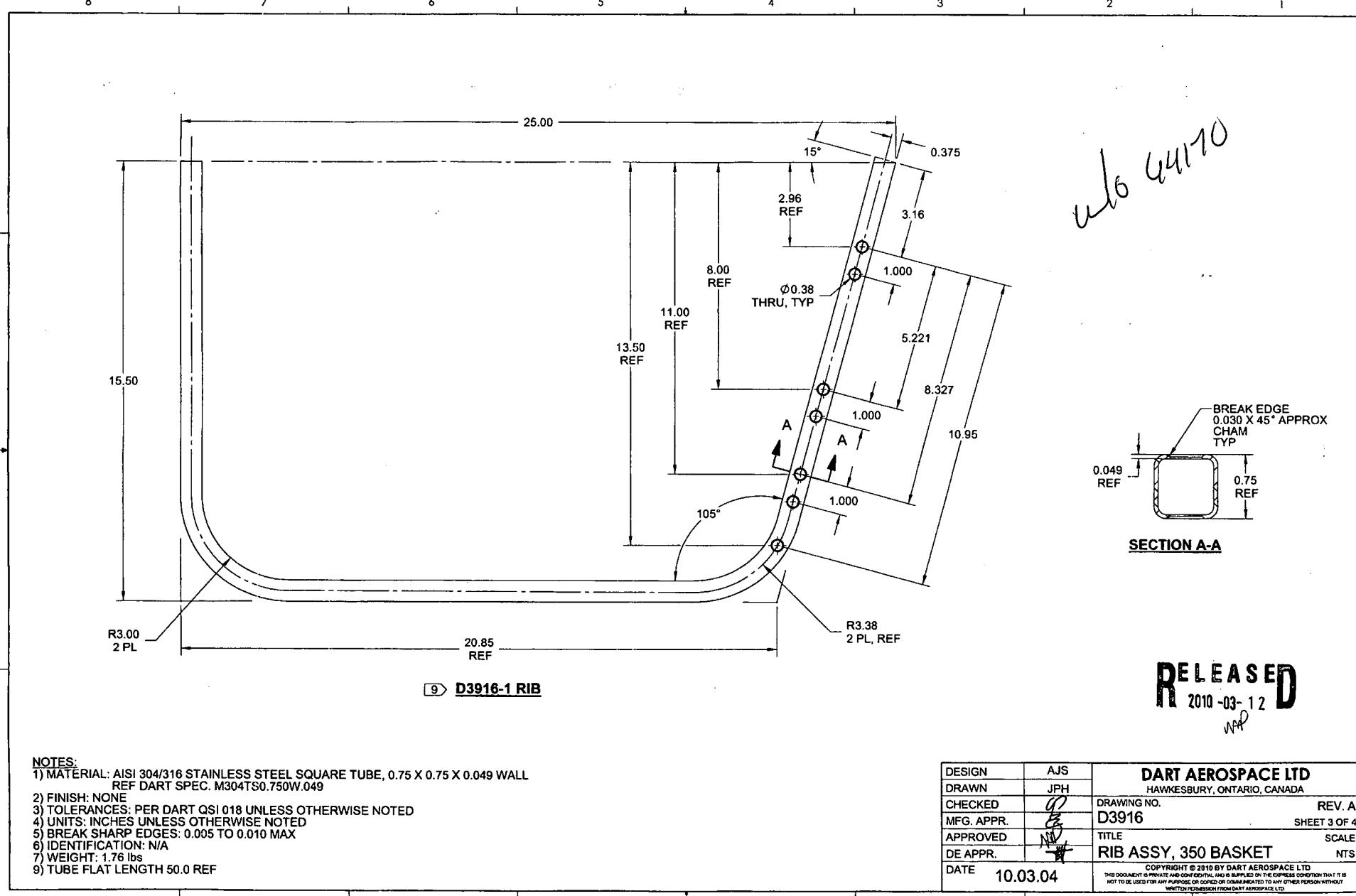
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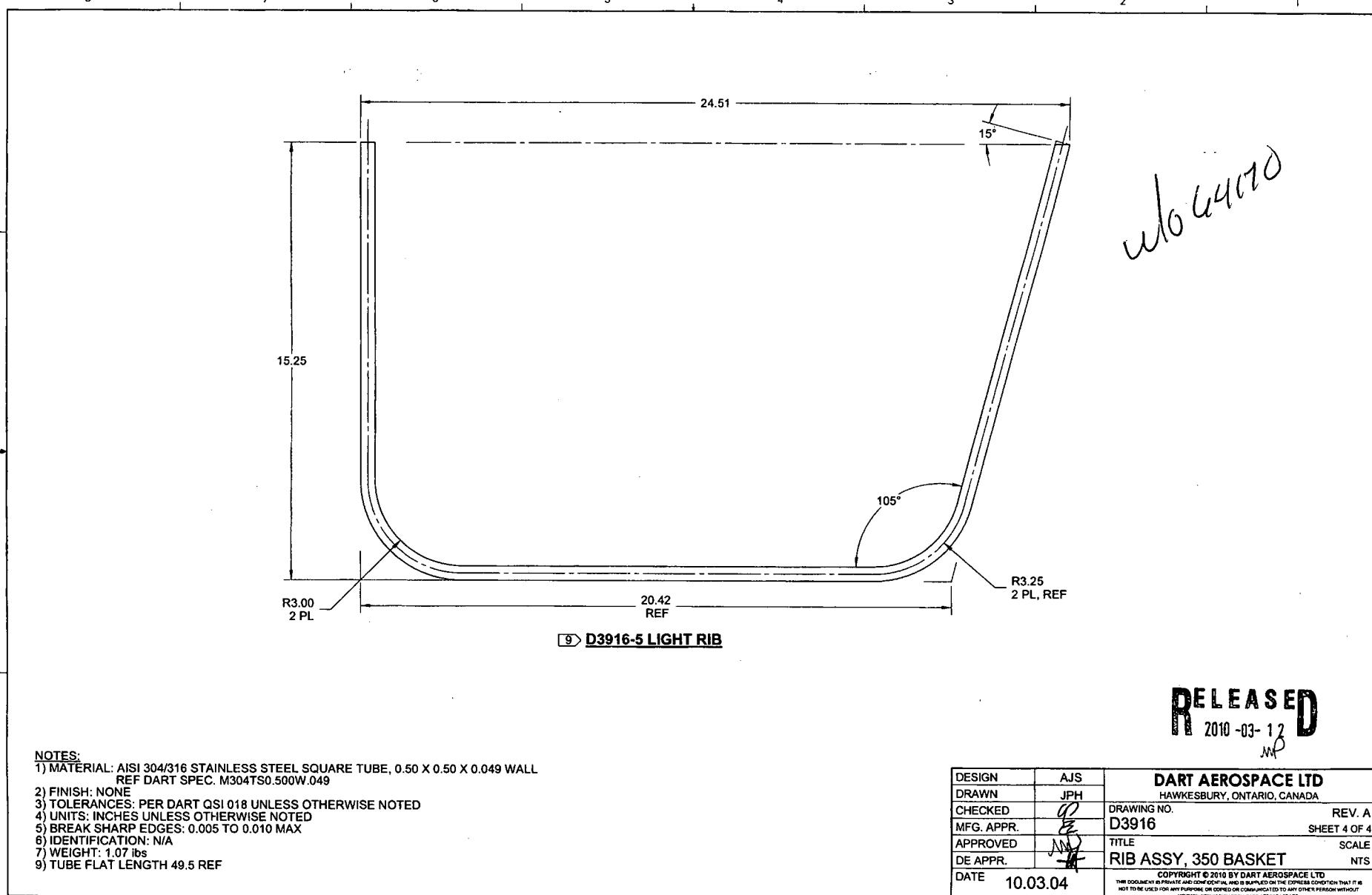
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